



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4884-1
Job Sheet 196476



Part No: D4884-1

Job Qty: 6 pcs

Part Name: End Fitting, Eye



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 6/24/19

Created By: Lorin Baltac

Type: Stock

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD IPP REV:B DOING PART IN HOUSE FROM NOW ON. RQ 16.11.02 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
105	Doosan - 1	6 pcs	6/24/19	6/24/19	1.00	4.51	Doosan - 1	
110	QC 2	6 pcs	6/24/19	6/24/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Container No: S197668



Part: D4884-1

Job No: 196476

Serial No/Batch: S197668

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/12/19

Plex 6/13/19 11:37 AM Dart.Baltac.Lorin

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
115 HAAS 5 Axis - B4B	6 pcs	6/24/19	0.75 5.56	HAAS - 5 - B4B	# 19-07-24
117 QC 2	6 pcs	6/24/19	0.00 0.00	QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	# 19-07-24
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120 QC 8	6 pcs	6/24/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	# 19-07-24
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	

				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130	Outsource - 2 - NDT per QSI038	6 pcs	6/24/19	SKY002-VC	6 <i>2019-07-24</i>
140	Packaging 2-1 - Receive - B4B	8 pcs	6/24/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
150	QC 5	6 pcs	6/24/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50

160	Packaging 3-1 - Stock - B4B	6 pcs	6/24/19	0.00 0.00	QC 5 - 30	JUL 26 2019
					QC 5 - 40	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	6 pcs	6/24/19	0.00 0.00	QC 21 - SA - 21	JUL 26 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 105 - (Doosan Lathe)-Machine blank as per Machinist's turning detail, folio+drawing D4884-1.
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 115 - (HAAS CNC vertical machine #5) Mill as per folio FB509.
 117 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Outsource process - NDT per QSI038 4.1)ISSUE P/O : _____
 140 - (Outsource process - NDT per QSI038 4.1)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: _____) IDENTIFY AS PER QSI 044 6.1
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.500	17-4 SS H900 Round Bar 1.500"	2.1000 ft (25 ea)	105-Doosan - 1	M129892 36"

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Doosan - 1	M17-4-H900-R1.500	2	68	0

Part Specifications
Specifications could not be found.

Plex 6/13/19 11:37 AM Dart.Baltac.Lorin

DART AEROSPACE LTD		Work Order: 196478
Description: End Fitting, Eye		Part Number: D4884-1
Inspection Dwg: D4884 Rev: A		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	.5025			Caliper	
1.17	+/-0.030	1.16				DAS
R0.63	+/-0.030	R.16				5
0.500	+/-0.005	.500				9-89
0.030	+/-0.010	.028				
0.017	+/-0.010	.019				DAS
Ø0.670	+0.000/-0.001	.6698			Micrometer	5
30°	+/-0.5°	30°				9-89
Ø0.125	+0.004/-0.001	.1265			Caliper	DAS
30°	+/-0.5°	30°				5
Ø0.125	+0.004/-0.001	.1265				9-89
Ø1.14	+/-0.030	1.14				
<i>Milling ↓</i>						
1.132	+/-0.010	1.132	✓		SLIO	Vern
Ø0.750	+0.000/-0.001	.7494	✓		"	
0.66	+/-0.030	.658	✓		"	
2.060	+/-0.005	2.061	✓		Height gauge	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.81	+/-0.030	1.809	✓		SLIO	Vern
3.65	+/-0.030	3.651	✓			
0.06 x 45°	+/-0.030 x +/-0.5°	.060 x 45°	✓			
0.947	+/-0.010	.948	✓			
0.059	+/-0.010	.060	✓			
0.063	+/-0.010	.063	✓			
R0.06	+/-0.030	.062	✓		Rad gauge	
0.200	+/-0.010	.199	✓		SLIO	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.39	+/-0.030	1.390	✓		SLIO	

Measured by: De / 20	Checked by: B.	QC Inspector:
Date: 19-07-23	Date: 19-07-24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	





skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41186	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044116 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON :

✓ (9) END FITTING EYE P/N# : D4884-1 ✓, J/S# : 196476 ✓

Action Taken:					Date:	Initial/Stamp:
MAGNETIC PARTICLES INSPECTION CARRIED OUT IAW ASTM E-1444M-16 ***NO CRACK FOUND*** MAGBENCH S/N 208123 CAL DUE: 25-SEP-2019 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO22794 BLACK LIGHT-M20186					JUL 25 2019	DOT-APP 310 53-89 EV 318 AS
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

RECEIVED

JUL 25 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp DOT-APP 310 53-89	Date: JUL 25 2019
Name: RICARDO VARGAS		